

Work Order ID 74873

October 13, 2011 10:37:16 AM

74873

Page 1

Item ID: D3502-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 10/13/11 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/11 Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3502	Rev B								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 3.475 " long1 BLANK MAKES 2 PARTS								

ok 11/12/12

20 Ø

110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B 2-Deburr per dwg D3502								

BC AD 11/12/12

20 Ø

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120	Memo	0.00							
QC									
Quality Control									

BC AD

20 Ø

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NR1

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NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 11/12/11

20 0

130

QC

Quality Control

140

140

Small Fab

Small Fab

0.00

SD 11/12/19 (20)

Small Fab

Memo

0.00

Mark hole position using DT9430Drill as per Dwg D3502.

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

20X MP 11/12/20

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Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

8-15

0.00

20X8M-LH/12/21

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

20 BL 16-10-21

180

Identify as per dwg & Stock Location:

63

0.00

180

Packaging

Memo

0.00

11/12/22 SPQ 2022

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Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release

0.00

1Q0

QC

Quality Control

Memo

0.00

W/12/2011

MF
11-12-22

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Picklist Print

Page 1

October 13, 2011 10:37:22 AM

Work Order ID: 74873

74873
D3502-1

Parent Item: D3502-1

Parent Item Name: Support

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 06-07-06 JLM
 IPP Rev:B Add tooling hole 07-03-28
 Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.000		Purchased	No			100	f	18.8130	0.289 0.1445	6.084211 3.0421			

M6061T6B1 000X04 000

6061-T6 Bar 1.00 x 4.00

Location	Loc Qty	Loc Code
MAT004	18.813	
→ 114352	1	
116808	0.787	
→ 118400	17.026	

1
2.023

and 11/2/12

M119346 X .28

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DART AEROSPACE LTD	Work Order:	74873
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SG / SH</u>	Audited by:	<u>CMF</u>	Prototype Approval:	N/A
Date:	<u>11/2/16</u>	Date:	<u>11/2/16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.03.29	Dwg Rev. updated	KJ/JLM	

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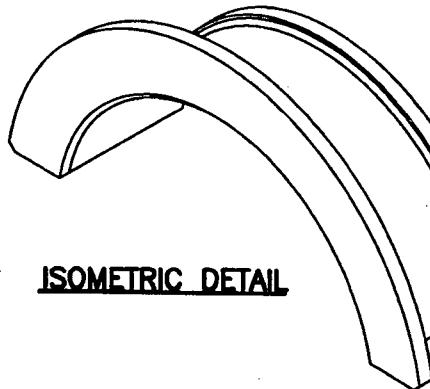
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3502
DATE		REV. B SHEET 1 OF 1
06.10.31		TITLE SUPPORT
A	06.04.18	SCALE 1:1
B	06.10.31	ADD TOOLING HOLE FOR FINISHING



OPTIONAL $\phi 0.098$ (DRILL #40)
TOOLING HOLE, CENTERED ON PART
(ONE PLACE ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

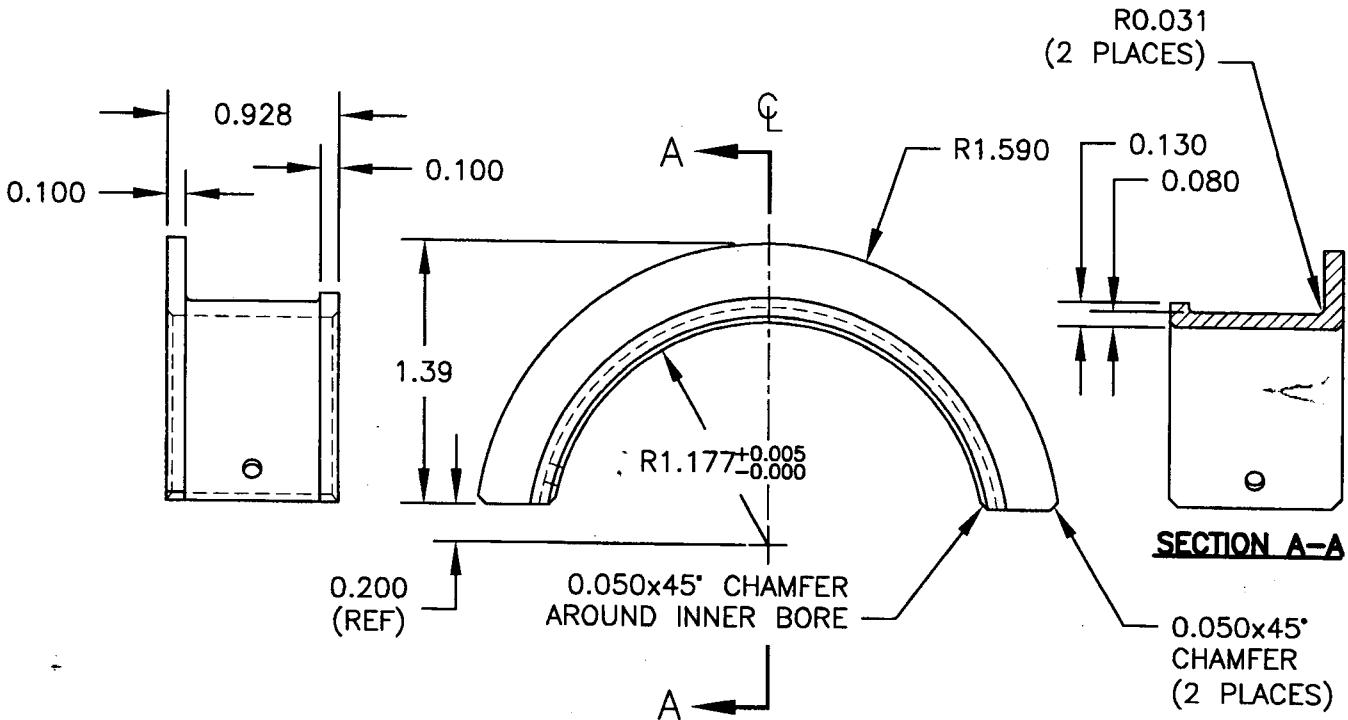
NO. 34873

RELEASED

06.12.06 CP
PER ECN 885

M.L.J.

11/10/14



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
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